



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2573

Job Sheet 184656



Part No: D2573

Job Qty: 4 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/15/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining		SBL
100	CNC Vertical Machining	4 pcs	11/2/18	11/2/18	1.01	6.67	HAAS 1		SBL
110	Mill Conv	4 pcs	11/2/18	11/2/18	0.00	0.67	Mill Conv 1		SBL
130	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC8		mmmc 14/11/19
140	HandFinish	4 pcs	11/2/18	11/2/18	0.00	0.19	HandFinish1		DR 18/11/20
150	Powdercoat	4 pcs	11/2/18	11/2/18	0.00	0.15	Powdercoat1		BEB 18-11-20
160	QC	4 pcs	11/2/18	11/2/18	0.00	0.00	QC3		NOV 21 2018
170	Packaging	4 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3	5398	NOV 21 2018
180	QC21-SA	4 Ea	11/2/18	11/2/18	0.00	0.00	QC21		DAS 21 NOV 21 2018

Part Op 100 - Program Batch No. _____

Descriptions: 110 - Machine keyway as per dwg D2573 & D2574

M138951 150 - START TIME: 9:20

TEMP: 320° FINISH: 9:50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	5082692

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	4	27	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Aft Outboard	7.990Inches	8.010		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																			
Misidentified ☐	Past Due ☐																				

			+ 0.020	7.990
			- 0.000	
6	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Outboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Outboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Outboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Aft Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Outboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

FAULT CATEGORY

ire	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
/Defect	☐ Weld	☐ Part Incorrect
mplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
mplete/Unclear	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 532-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/09/18

Instructions: Various STC's



Container No: S126414
Part: D2573
Job No: 184656
Serial No/Batch: S126414

Revision:
Inspector:
Exp Date:

DART AEROSPACE LTD	Work Order: 184656
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.999	8.000	8.000		
F	0.490	0.510		.500	.500	.502	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.499	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.567	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.133	.131	.130		
Q	0.115	0.135		.126	.126	.125	.127		
R	0.240	0.260		.253	.252	.251	.252		
S	0.115	0.135		.126	.125	.125	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.238	.240	.240	.240		
W	0.115	0.135		.128	.126	.125	.125		
X	0.308	0.313		.310	.310	.310	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.364	.364	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.624	.624	.625		
AC	0.053	0.073		.057	.057	.057	.059		
AD	0.240	0.260		.249	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.123	.128	.120	.122		
AG	0.240	0.280		.248	.250	.250	.250		
AH	0.240	0.260		.247	.247	.246	.248		
AI	2.000	2.020		2.010	2.010	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	DAS
Date:	57 18/11/11
	9-89

Audited by:	AMML
Date:	18/11/19

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 184 656
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	37	8 #		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.75		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		0.502	0.502	0.502	0.5		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.500	0.500	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.567	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.125		
P	0.115	0.135		0.127	0.135	0.128	0.128		
Q	0.115	0.135		0.125	0.126	0.125	0.126		
R	0.240	0.260		0.251	0.251	0.251	0.252		
S	0.115	0.135		0.124	0.125	0.128	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.241	0.240	0.240	0.240		
W	0.115	0.135		0.125	0.124	0.124	0.125		
X	0.308	0.313		0.312	0.312	0.313	0.313		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.625		
AC	0.053	0.073		0.058	0.060	0.060	0.060		
AD	0.240	0.260		0.250	0.249	0.250	0.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.132	0.120	0.120	0.120		
AG	0.240	0.280		0.250	0.250	0.245	0.245		
AH	0.240	0.260		0.245	0.246	0.245	0.245		
AI	2.000	2.020		2.010	2.010	2.010	2.010		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by:	DAS
Date:	57 18/11/11

Audited by:	Amuly
Date:	18/11/11

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 184 656	
Description: Saddle, Aft Outboard		Part Number: D2573	
Inspection Dwg: D2573 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9 1	10 2	11 3	12 4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.000	8.000		
F	0.490	0.510		0.501	0.501	0.499	0.498		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.501	0.501	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5675	0.567	0.567	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.126	0.127	0.127	0.127		
R	0.240	0.260		0.252	0.255	0.250	0.252		
S	0.115	0.135		0.128	0.127	0.127	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.242	0.242	0.240		
W	0.115	0.135		0.127	0.126	0.126	0.126		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.627	0.623	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.251	0.251	0.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.250	0.250	0.250	0.250		
AI	2.000	2.020		2.010	2.010	2.010	2.010		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: DAS	Audited by: <i>mgl</i>
Date: 57 18/11/11	Date: 18/11/19
9-89	

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
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